

Work Order ID 66282

Thursday, February 10, 2011 2:27:51 PM



DUPLICATE

Page 1

Item ID: D4150-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Attachment Arm Assembly

Start Date: 2/8/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 2/23/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4150	B

100 0.00



Small Fab

Small Fab

Memo

1- Assemble as per dwg
~~Trim rivets to 1.250" long~~

0.00

SB 11/02/10

(2)

110 0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

Solo 11/02/10

(x2)

120 0.00



Packaging

Packaging

Identify as per dwg & Stock Location: 133

Memo

0.00

11/02/11 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Accept

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

2/10/11
MF

11-02-11

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Picklist Print

Thursday, February 10, 2011 2:27:47 PM

Page 1

Work Order ID: 66282

Parent Item: D4150-041

Parent Item Name: Attachment Arm Assembly




Start Date: 2/8/2011

Required Date: 2/23/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.06.24 new issue DD verf:EC
IPP Rev:B 10.07.22 as per revB DD verf:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C13A  Bolt		Purchased	No			100	Each	41.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST351				41					
				115335				5					
				115457				16		4			
				115768				20					
D4150-1  Arm		Manufactured	No			100	Each	6.0000	1	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST123				6					
				61011				6		2			
D4150-3  Arm Plate		Manufactured	No			100	Each	6.0000	2	4			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST123				6					
				61012				6		61012			

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 66282



Parent Item: D4150-041



Parent Item Name: Attachment Arm Assembly

Start Date: 2/8/2011

Required Date: 2/23/2011

Start Qty: 2.00

Required Qty: 2.00

MS21043-3

Purchased

No

100

Each

1,357.000

2

4



SB 11/02/10

Nut

Location

Loc Qty

Loc Code

FG

76

103691

76

ST301

1281

112314

1281

4

NAS1149C0332R

Purchased

No

100

Each

3,344.000

4

8



SB 11/02/10

Washer

Location

Loc Qty

Loc Code

ST297

3344

115000

125

115698

35

116025

232

116304

2952

8

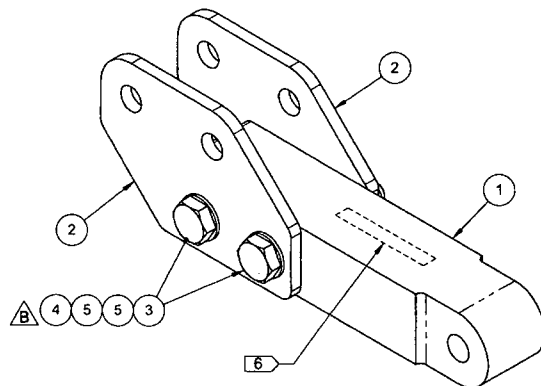
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

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D4150-041 ATTACHMENT ARM ASSY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4150-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.82 lbs

ITEM	QTY	P/N	DESCRIPTION
	X	D4150-041	ATTACHMENT ARM ASSY
1	1	D4150-1	ARM
2	2	D4150-3	ARM PLATE
3	1	AN3C13A	BOLT
4	1	MS21043-3	NUT
5	2	NAS1149C0332R	WASHER

RELEASED
2010-07-16

B	REPLACED QTY(3) MS20815-4M20 WITH QTY(2) EACH AN3C13A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN C6-2, C7-2, B4-3 & B5-3). REASON: SEE TR-D350-607-2 REV. B.		MB	10.07.08
A	NEW ISSUE		MB	10.06.18
REV.	DESCRIPTION		BY	DATE
DESIGN	DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
DRAWN	DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
CHECKED	DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
APPROVED	DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
DE APPR.	DART AEROSPACE LTD		HAWKESBURY, ONTARIO, CANADA	
DATE	10.07.08		10.07.08	
DRAWING NO.		D4150		REV. B
TITLE		ATTACHMENT ARM ASSY		SCALE
DATE		10.07.08		NTS

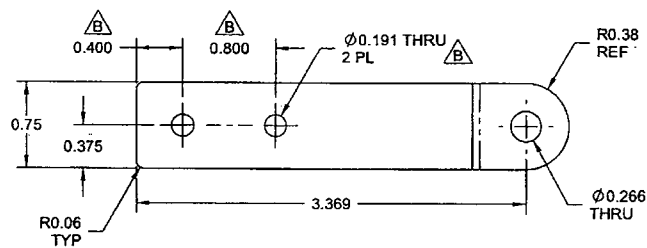
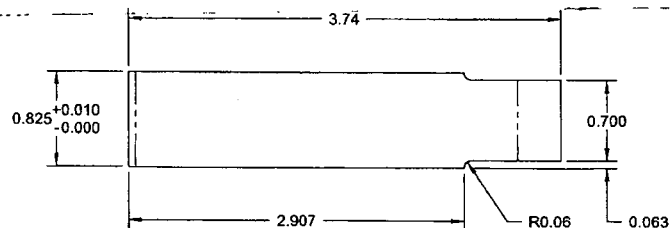
W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

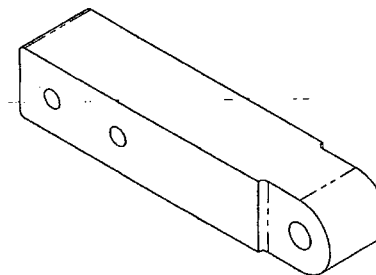
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NOTE: Date & initial all entries



D4150-1 ARM



#66282

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.60 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
DATE	10.07.08	<small>COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE RELEASED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

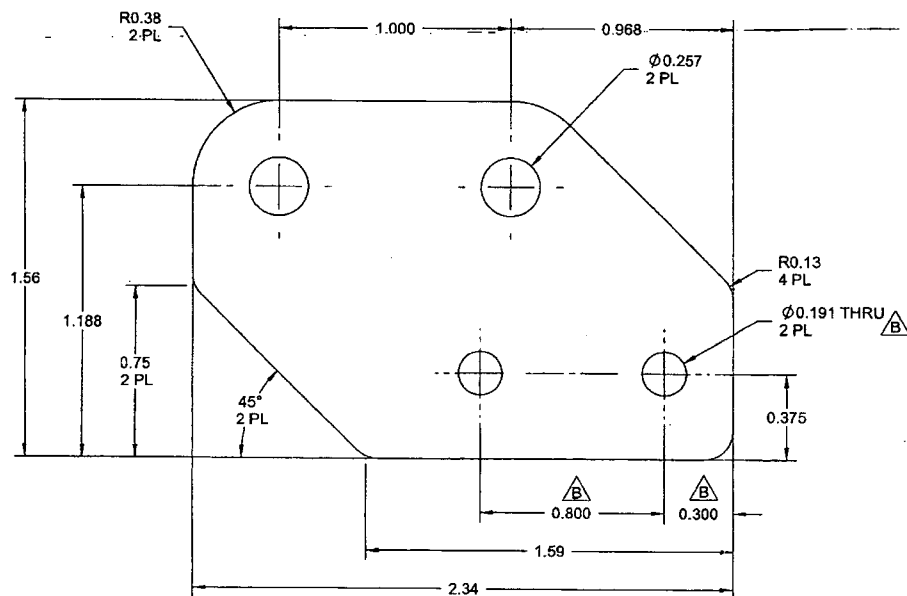
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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D4150-3 ARM PLATE

RELEASED
2010-07-16

NOTES:

- 1) MATERIAL: 303/304/316 STAINLESS STEEL 0.125" THICK SHEET ANNEALED 2B FINISH, PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240 REF DART SPEC M304S11GA OR M303S11GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.10 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D4150	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		ATTACHMENT ARM ASSY	NTS
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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